



Date: Wednesday, 15/08/2007 3:48:40 PM
User: Linda Lacelle

Process Sheet

SPRIT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L FLOAT STEP
Job Number	: 33921	Part Number	: D206628023
Estimate Number	: 10851	Drawing Number	: N/A
P.C. Number	: N/A	Project Number	: N/A
This Issue	: 15/08/2007 S.O. No. : N/A	Drawing Revision	: N/A
Prsht Rev	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 31/08/2007
Previous Issue	: 33758	Qty:	1 Um: Each
Written By	: 		
Checked & Approved By	: 		
Comment	: Est Rev:D As Per Ecn766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description:
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-023 CHG 002

KS 07.08.27 (1)

2.0	33921A	FLOAT STEP ASSEMBLY LH (206/407)
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Comment: Sub-Component Sub-Assembly

FLOAT STEP ASSEMBLY LH (206/407)

D2842-041 B 33921A

27/9/14 (1)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D27317	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-7 Mounting Lug B33420

5.0	D28441	Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2844-1 Arm B33760

7/9/14 SK
10 B34000 (1)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 33921

Part Number: D206628023

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2844-3 Arm B33898

7.

D2856400

Abrasion Strip



Comment: Qty.: 1.2660 f(s)/Unit Total: 5.0639 f(s)

Pick:

Qty Part # Description Batch

2 D2856-400 6.9" Abrasion Strip B32992

8.

D3394043

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3394-043 LUG ASS'Y B30998

9.

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN3C4A Bolt M105143

10.

AN4C12A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4C12A Bolt M104937

Process Sheet

Cus omer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 33921

Part Number: D206628023

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN4C13A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C13A

Bolt

M105289

12.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

M103915

13.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total : 12.0000 EACH(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10

WASHER

M101064

14.0

AN960JD416L

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960JD416L

Washer

M105078

15.0

NAS1515H4L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L

Washer

M105143

This Batch

82X

M10513L

14X

16.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21043-4

Nut (or MS21042-4)

M105115

Wednesday, 15/08/2007 3:48:40 PM
Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 33921

Part Number: D206628023

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

NAS1515H3

Washer



Comment: Qty.: - 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 NAS1515H3 Washer

m105164

CE 7/9/10 (4)

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

70709.14 (1) 1 kit.

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-023

Location:

PPP Rev:

CE 7/9/10 (1)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

CE 7/10/17 (1)

Job Completion



CE 7/10/17


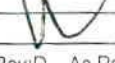
SPLIT

618.023

Dart Aerospace Ltd.

Date: Wednesday, 15/08/2007 3:48:53 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT STEP ASSEMBLY LH (206/407)
Jot Number	: 33921A	Part Number	: D2842041
Estimate Number	: 11664	Drawing Number	: D2842 REV B
P.C. Number	: N/A	Project Number	: N/A
This Issue	: 15/08/2007 S.O. No. : N/A	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Due Date	: 31/08/2007
Previous Run	: 33758A	Qty:	Um: Each
Written By	: 		
Checked & Approved By	: 		
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Jot Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Qty Part # Description Batch:
1 D2622-120C Extrusion B.32858

Check Material for any Dents or Defects

a-m 07.08.29 4

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

a-m 07.08.29

2-Drill D2842-1 using Jig DT8271 as per Dwg D2842

a-m 07.08.29

3-Deburr and bevel ends for welding

a-m 07.08.29

4

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>330883</u>

16 07.09.04 4

Date: Wednesday, 15/08/2007 3:48:53 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 33921A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D34593

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3459-3 Lug

B 33226

Pl 07.09.04 4

5.0

D34591

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description

2 D3459-1 Lug

Batch

B 33807

Pl 07.09.04 4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT

followed by DT as per Dwg D2842

A/R AL Rod Batch: m103794

m104721

2-Grind end cap weld flush

a.m

07.09.04

Pl 07.09.04 4

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/04 (x441)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/09/04 (4)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 07.09.04

4

Date: Wednesday, 15/08/2007 3:48:53 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 33921A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/09/05 (4)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Q.M 07.09.05 (4)

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M103794

FL 07.09.05 4

2-Grind end cap weld flush.

Q.M 07.09.06

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

FL 07/09/06 (4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FL 07/09/06 x (4) LH

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

M. K (Touch up alodine)

FL 07/09/06 (4) LH

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/09/06 (4) LH

16.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description Batch

3

NAS1329C3KB130Insert

M105385 (7x)

M104474 (5x)

M. K 07/09/07

Date: Wednesday, 15/08/2007 3:48:53 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 33921A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 MS27039C1-07

Screw

M104936

M.L

18.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3 NAS1515H3L

WASHER

M104603

~~M105143~~

M.L

19.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10L

WASHER

M105143

M.L

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: M105380

M.L

07/09/07

(4X)

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/07

X4 LH

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PDP 33921

07/09/07

07/09/07

Date: Wednesday, 15/08/2007 3:48:53 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 33921A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
12/09/19



Job Completion



U 07-09-18

Date: Friday, 07/09/2007 1:11:06 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206-628
Job Number : 34468	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : Z_CUSTOM
This Issue : 07/09/2007 S.O. No. : N/A	Drawing Number : ECN 1029
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : 	Due Date : 14/09/2007
Checked & Approved By : 	Qty: 1 Um: Each
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STK - ADD NEW PAPERWORK PER ECN 1029

EASA STC: EASA.IM.R.S.01339 :

D206-628-011

33411 (3X)

33038 (4X)

32979 (1X)

D206-628-012

32980 (1X)

33892 (1X)

D206-628-013

D206-628-014

18533 (1X)

18943 (1X)

D206-628-021

31976 (3X)

33756 (3X)

29739 (1X)

D206-628-021BL

33649 (2X)

D206-628-022

33757 - 31977 (3X)

D206-628-023

33921 (1X)

D206-628-024

33922 (1X)

D206-628-031

31010 (4X)

D206-628-032

29738 (1X)

31011 (4X)

D206-628-033

30806 (2X)

31241 (2X)

D206-628-034

30807 (2X)

1/8/11 SP